

Work Order ID 131500

Monday, April 13, 2015 10:03:41 AM

131500

0205-541-044

Page 1

Item ID: D2512 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid
 Start Date: 4/13/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/1/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 5-4-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2512	G								

100 Weld per dwg A/R S.S. rod Batch: B125054 0.00
 Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- Weld ribs as per Dwg D2512 using Welding Jig DT 9436

INSTALL D2012-117 CLEVIS ONLY ON D130-701-XXX

2- WELD MESH AND REMOVE SECTIONS OF MESH WHERE INDICATED AS PER DWG

1x CC 15-5-7

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

① 15-05-08

DAS
9
9-89

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131500

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/13/2015 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 5/1/2015 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

OC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

① 15-03-08

14/15-5-8. DAS 34 9-89

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum M 131545	0.00				1	6	1558	
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug all holes prior to Powdercoat								
	1ST COAT: START TIME: <u>9:10</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>9:40</u>								
	2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
140		0.00							
140	HandFinishing					1x	6	211505/14	
HandFinish	Memo	0.00							
Hand Finishing	Wing Walk and Spray Paint black as per Dwg D2512 and OSI 005 4.4 Batch: <u>11132639</u>								

DAS 34 9:00

Work Order ID 131500***131500***

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Lid

Start Date: 4/13/2015 Start Qty: 1.00

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Required Date: 5/1/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							38 9-89
150									
QC	Memo	0.00							MAY 11 2015
Quality Control									
160	Identify as per dwg & Stock Location: <u>W10</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

15/5/11
mf
15-5-11

Picklist Print

Monday, April 13, 2015 10:03:35 AM

Page 1

Work Order ID: 131500

131500

Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

Comments:

Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
 VERIFIED BY:DD
 IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
 by:EC IPP Rev:R
 10.06.29 added pressure wash DD verf:EC IPP REV:S 12.07.27 AS
 PER DWG REV.F DD VERF:EC IPP REV:T 12.08.08 AS PER DWG
 REV.G DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-117		Manufactured	No			100	Each	28.0000	2	2			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2012-117

Clevis

Location	Loc Qty	Loc Code
WA004	28	
124563	11	
125440	7	
127735	10	

*** ONLY APPLICABLE ON D130-701-041 -IF
 NOT USED, PLEASE MARK N/A ***

D2232-1		Manufactured	No			100	Each	29.0000	2	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2232-1

Basket Hinge

Location	Loc Qty	Loc Code
WA004	29	
105333	15	
105885	14	

D2236		Manufactured	No			100	Each	0.0000	4	4			
-------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D2236

Lid Rib

125443

4

DL 15/5/5

DL 15/5/5

Picklist Print

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Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

D2506 Manufactured No 100 Each 18.0000 1 1

D2506

Label Plate

**

Dh 15/5/5

Location

Loc Qty

Loc Code

WA004

18

102257

11

103156

2

99826

5

D2512-3 Manufactured No 100 Each 4.0000 2 2

D2512-3

Rib

**

131506

2

Dh 15/5/5

Location

Loc Qty

Loc Code

WA004

4

127398

4

D2512-5 Manufactured No 100 Each 0.0000 6 6

D2512-5

Rib

**

131511

6

Dh 15/5/5

D2512-7 Manufactured No 100 Each 4.0000 3 3

D2512-7

Rib

**

Dh 15/5/5

Location

Loc Qty

Loc Code

WA004

3

125423

3

WA006

1

125424

1

131508

3

Picklist Print

Monday, April 13, 2015 10:03:35 AM

Work Order ID: 131500

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Parent Item: D2512

D2512

Parent Item Name: Basket Lid

Start Date: 4/13/2015

Required Date: 5/1/2015

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 91.0000 2 2

D2581

Mounting Bracket

**

Dh 15/5/5

Location

Loc Qty

Loc Code

WA004

91

102265

36

127716

39

131144

16

D3825-043 Manufactured No

100

Each

0.0000

2

D3825-043

Rib Assembly (Basket End, Lid)

D3832-13

Manufactured No

100

Each

0.0000

1

D3832-13

Mesh (Lid)

D3833-7

Manufactured No

100

Each

13.0000

2

D3833-7

Mesh (Lid End)

**

Dh 15/5/5

**

B132305 → 1 CC 15-5-7

**

CC 15-5-7

Location

Loc Qty

Loc Code

WA004

4

127675

2

127676

2

WA006

9

105442

1

114377

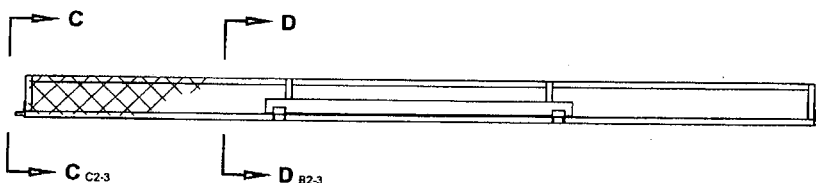
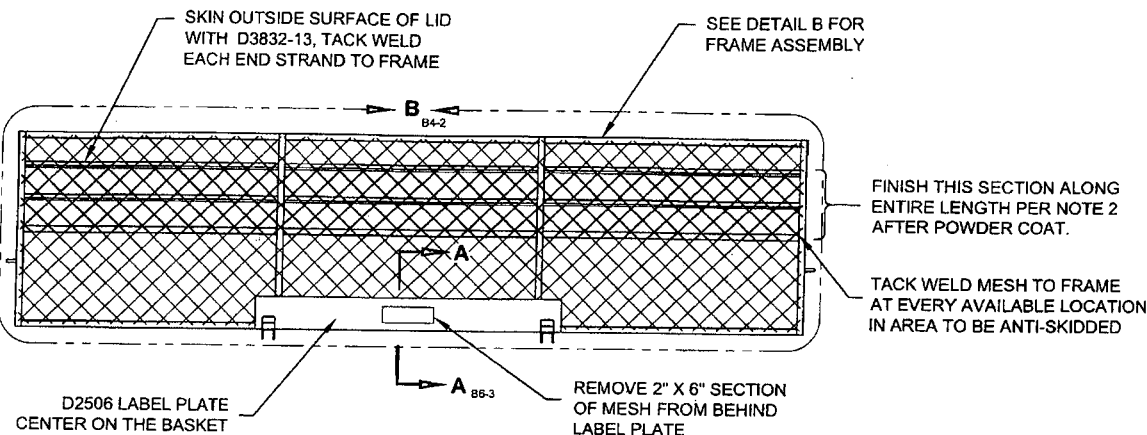
8

2x

QTY	PART NUMBER	DESCRIPTION
X	D2512	BASKET LID ASSEMBLY
2	D2512-3	RIB
6	D2512-5	RIB
3	D2512-7	RIB
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-13	MESH (LID)
2	D3833-7	MESH, LID END

mf
#131500

RELEASED
2012-09-03



D3833-7
TYP, BOTH ENDS

D2512 BASKET LID ASSEMBLY NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
AFTER POWDER COAT, SPRAY PAINT BLACK INSIDE SURFACE AND
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACES PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

G	CORRECTED TYPO: D3825-043 WAS D3825-041 (ZN D3-1, B8-2, B1-2)	MB	12.07.26
F	GENERAL REVISION: REFORMATED DWG; DELETED DETAIL E AND RELATED NOTES IN VIEW C-C. REASON: PAR10-50.	MB	12.05.11
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. G
MFG. APPR.	AS	D2512	SHEET 1 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET LID ASSEMBLY (350/212)	NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

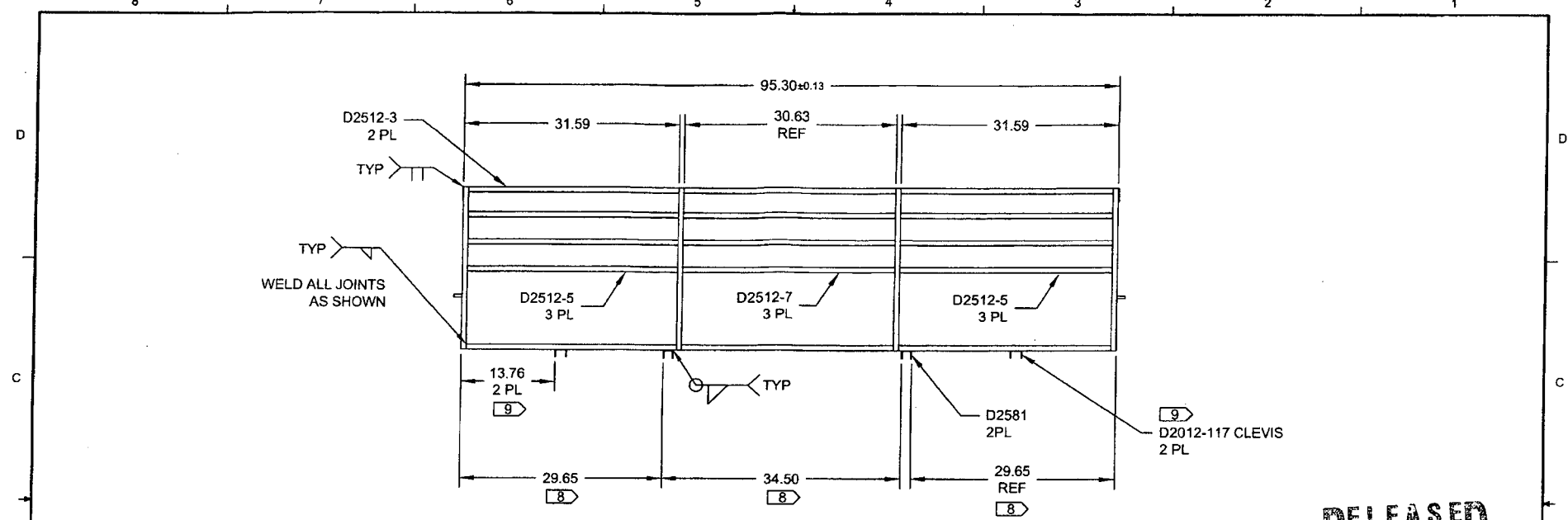
**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

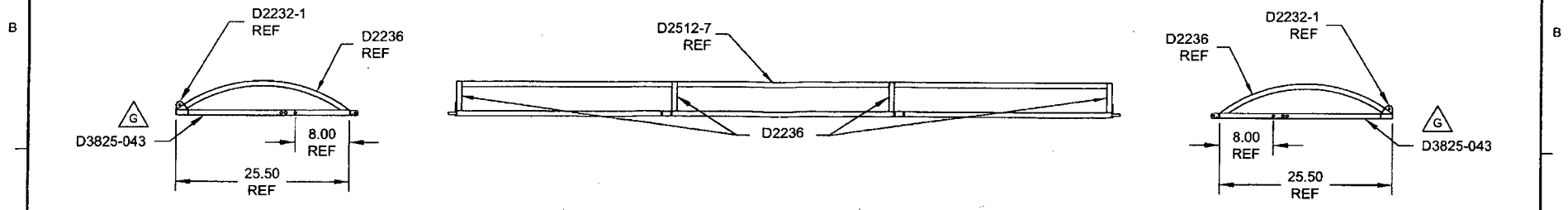
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐																		

8 7 6 5 4 3 2 1



DETAIL B D6-1
FRAMEWORK ONLY SHOWN FOR CLARITY

RELEASED
2012-00-03
JMP



- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
 - 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.	JMP	D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

DQA: _____ Date: _____

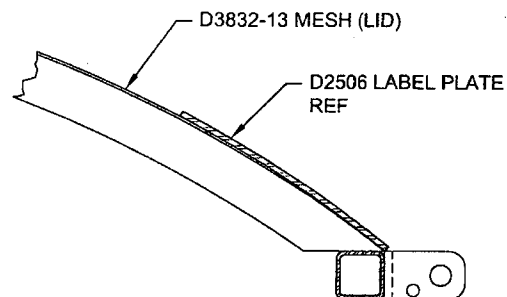


WORK ORDER NON-CONFORMANCE / UPDATE

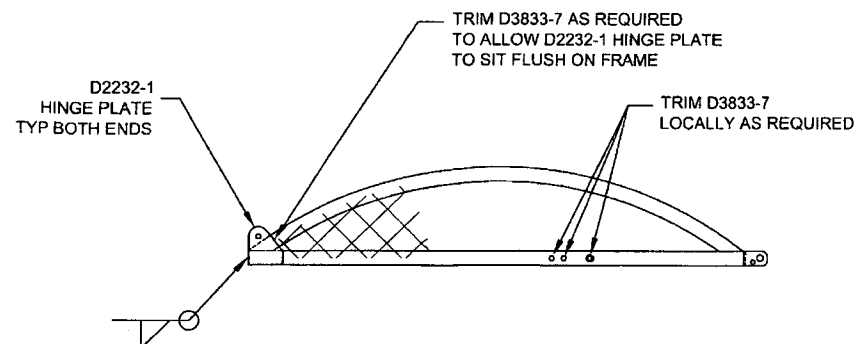
QA Closed: _____ Date: _____

Work Order update only ☐

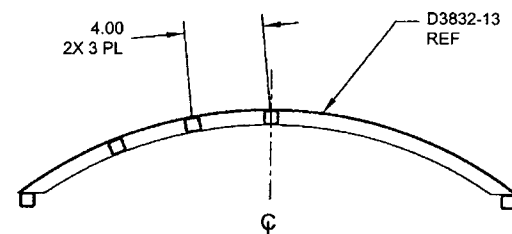
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SECTION A-A
(ROTATED 90° CCW) C6-1



VIEW C-C SIMILAR BOTH END RIBS B8-1



SECTION D-D SAME BOTH CENTER RIBS B7-1

RELEASED
2012-08-03
MP

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____

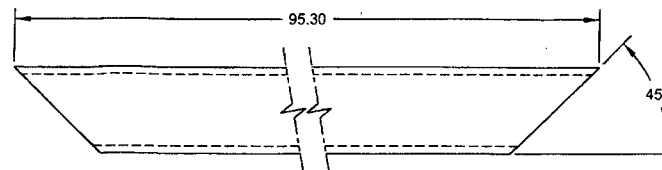
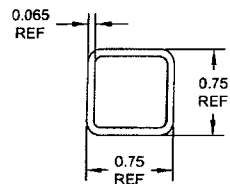


WORK ORDER NON-CONFORMANCE / UPDATE

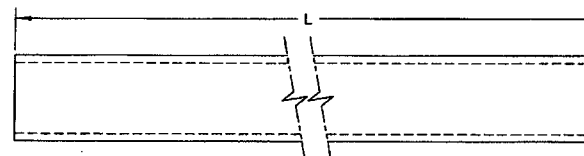
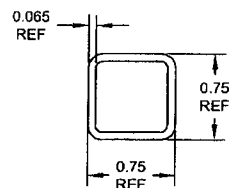
QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER :																																																																							



D2512-3 RIB



D2512-X RIB

DART PART NUMBER	L
D2512-5	30.84
D2512-7	30.63

RELEASED
2012-08-03

D2512-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO. D2512	REV. G SHEET 4 OF 4
MFG. APPR.	[Signature]	TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS
APPROVED	[Signature]	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	[Signature]		
DATE	12.07.26		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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